Work Order ID 75082

October-17-11 10:51:37 AM

75082

Item ID: D3886-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Lug Assembly

Start Date: 17/10/2011 **Start Qty:** 8.00 *8* **Cust Item ID:**

Required Date: 28/10/2011 **Req'd Qty:** 8.00 *8* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** M.C.J **Date:** 11/10/17 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3886	B ~~A~~ E								
100		0.00							
100						B11-10-21			
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	FLOW WATER JET								
304.108	1-Cut as per Dwg D3886-3								
	Dwg Rev: B								
	Prog Rev: B								
	2-Deburr if necessary B11-10-29								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						B11-10-21			
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item ID: D3886-041 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Lug Assembly
Start Date: 17/10/2011 **Start Qty:** 8.00 *8*
Required Date: 28/10/2011 **Req'd Qty:** 8.00 *8*
Reference:
Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00				8			
130 *130* Brake NC Brake NC	**Memo** form as per dwg D3886	0.00 0.00				8			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00							

11-11-03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 75082

October-17-11 10:51:37 AM

75082

Item ID: D3886-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Lug Assembly

Start Date: 17/10/2011 **Start Qty:** 8.00 *8*

Required Date: 28/10/2011 **Req'd Qty:** 8.00 *8*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00				9		EL 12-5-17	
150									
Large Fab	**Memo**	0.00							
Large Fab	Weld as per Dwg D3886 and QSI 004 use DT9626 A/R SS ROD Batch: M120012								
160	QC9- Inspect visual per QSI004- Fusion Welds	0.00				9x	Ø	GC 10.05.19	
160									
QC	**Memo**	0.00							
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00				KE			
170									
QC	**Memo**	0.00							
Quality Control									

5/12/05/22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 75082

October-17-11 10:51:37 AM

75082

Item ID: D3886-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Lug Assembly
Start Date: 17/10/2011 **Start Qty:** 8.00 *8*
Required Date: 28/10/2011 **Req'd Qty:** 8.00 *8*
Reference:
Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00 Start Time: 9:20				9X	0		M.L 12/05/23
180 Powdercoat	**Memo**	0.00 Temp: 400°F							
Powder Coating	M12/134	Finish Time: 9:50							
190	QC3- Inspect Part Finish	0.00							
190 QC	**Memo**	0.00				9x	0		M 12/05/23
Quality Control									
200	Identify as per dwg & Stock Location: S14G7	0.00							
200 Packaging	**Memo**	0.00				9		SMC	12/5/23
Packaging									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item ID: D3886-041
Revision ID:
Item Name: Lug Assembly
Start Date: 17/10/2011 **Start Qty:** 8.00 *8*
Required Date: 28/10/2011 **Req'd Qty:** 8.00 *8*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00					12/5/25		
210									
QC	**Memo**	0.00							
Quality Control									

ME
12-05-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

October-17-11 10:51:41 AM

Work Order ID: 75082 *75082*

Parent Item: D3886-041 *D3886-041*

Parent Item Name: Lug Assembly

Start Date: 17/10/2011 **Required Date:** 28/10/2011

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA *M304S12GA* 304/316 0.100" Sheet		Purchased	No			100	sf	139.5800	0.1472 **	1.1776 B11-10-21			
				Location		**Loc Qty**		**Loc Code**					
				MAT019		139.58							
					113062	118.3				113062			
					113077	21.28							
D3886-1 *D3886-1* Lug		Manufactured	No			150	Each	5.0000	1 **	8 A 12-5-17			
				Location		**Loc Qty**		**Loc Code**					
				WA030		5							
					52646	5				5			

78919. ℓ 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

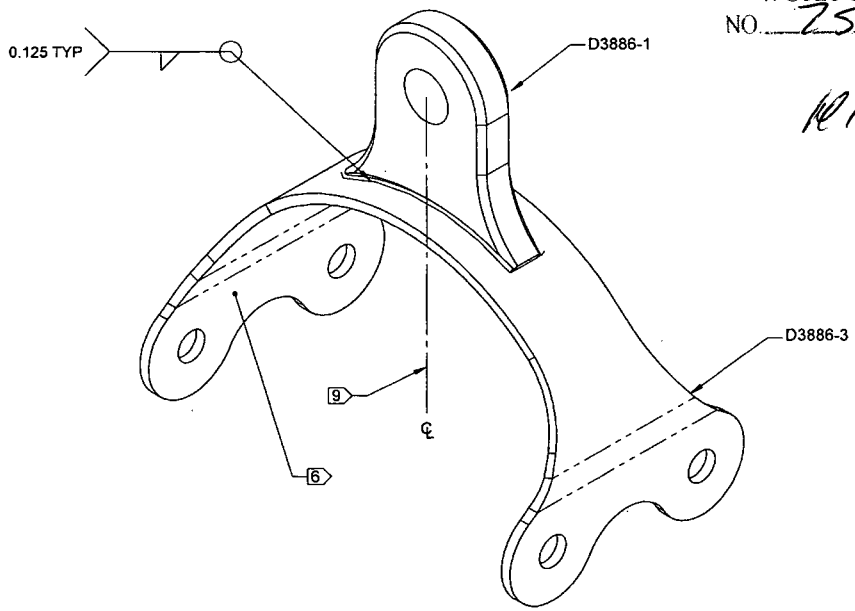
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

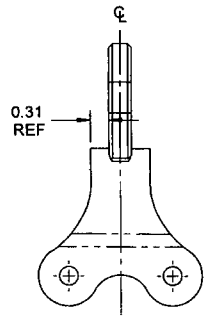
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75082

10-11-17

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3886-041	LUG ASSEMBLY
2	1	D3886-1	LUG
3	1	D3886-3	BRACKET





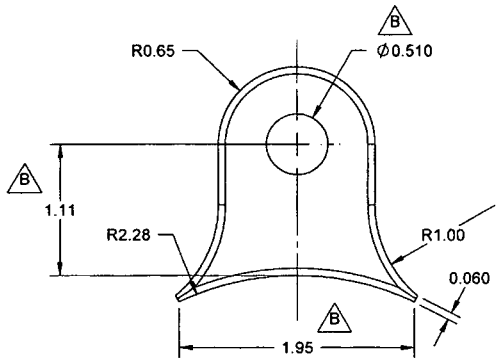
D3886-041 LUG ASSEMBLY

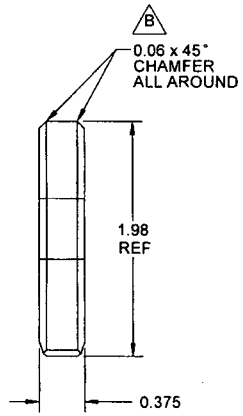
RELEASED
9/6/15 MP

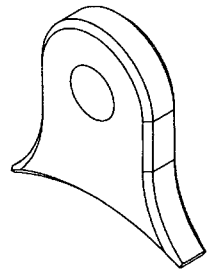
NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3886-041" AND BATCH NUMBER USING FINE POINT PERMANENT INK MARKER ON UNDERSIDE OF PART
7) WEIGHT: 0.53 lbs
8) WELD PER DART QSI 004
9) BOTH PARTS CENTER SHOULD BE IN LINE WITH THE ℄

REV.	DESCRIPTION	BY	DATE
B	RE-DESIGN D3886-1 (ZN B4-2); RE-DESIGN D3886-3 (ZN A4-3); REVISED D3886-3F (ZN B4-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3886	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
DATE	09.06.30		







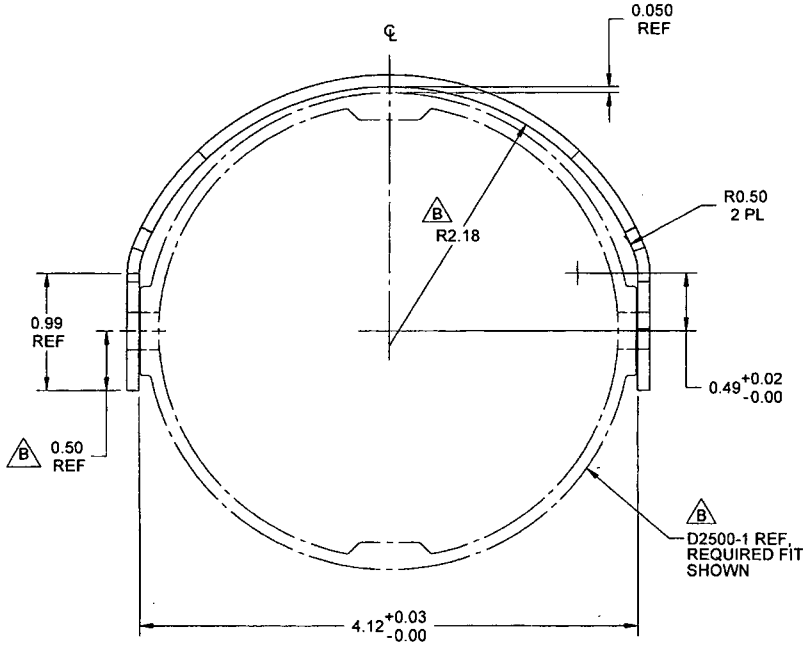
75082

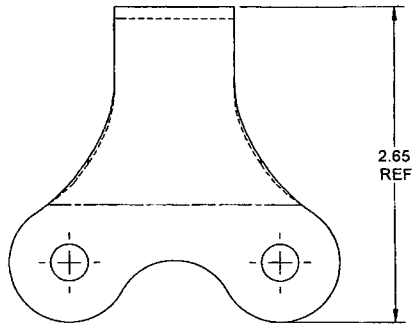
D3886-1 LUG B

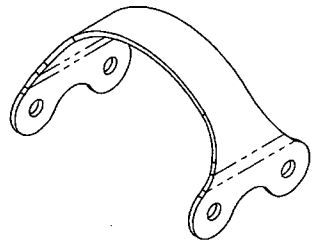
RELEASED
07/07/15 MW

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR (REF. DART SPEC. M304B0.750X2.500)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.23 lbs

DESIGN	RF	**DART AEROSPACE USA, INC.**	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3886	REV. B
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE LUG ASSEMBLY	SCALE NTS
DE APPR.			
DATE 09.06.30			





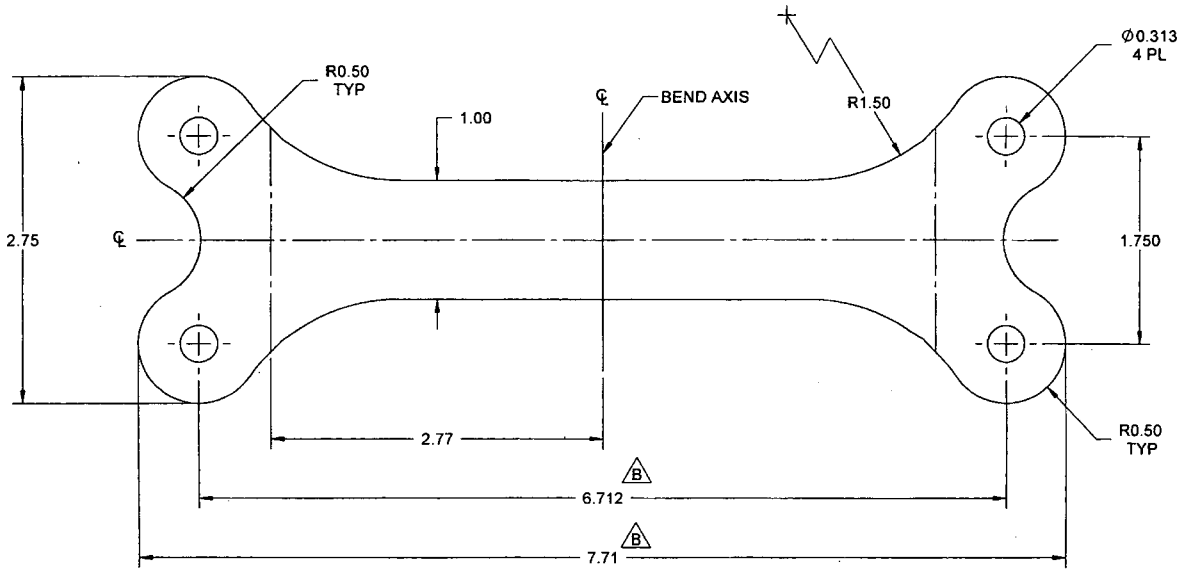


75082

RELEASED
9/6/15 MD

D3886-3 BRACKET B
(MAKE FROM D3886-3F)

DESIGN	RF	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO. D3886	REV. B
MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE LUG ASSEMBLY	SCALE NTS
DE APPR.			
DATE 09.06.30			



75082

D3886-3F FLAT PATTERN B

RELEASED
9/07/15 AM

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 12 GAUGE (0.100) THICK, (REF. DART SPEC. M304S12GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.30 lbs

DESIGN	RF	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	RF	DRAWING NO. D3886 REV. B SHEET 4 OF 4
CHECKED		TITLE LUG ASSEMBLY SCALE NTS
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.06.30	

DART AEROSPACE LTD	Work Order: 75082
Description: Lug Assembly	Part Number: D3886-041
Inspection Dwg: D3886-3 , Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [X] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .313	+.006 -.001	.316	✓		V RBG7	
1.750	+/- .010	1.752	✓		V	
2.750	+/- .010	2.755	✓		V	
1.00	+/- .38	1.614	✓		V	
2.77	+/- .03	BEND				
7.71	+/- .38	7.713	✓		V	
6.712	+/- .010	6.710	✓		V	
.100	+/- .010	.104	✓		V	

Measured by: RB	Audited by:	Prototype Approval:
Date: 11-10-21	Date: 11/10/25	Date:

Rev	Date	Change	Revised by	Approved
A		New issue	KJ/JLM	